

Date: Thursday, 20/11/2008 3:37:33 PM
 User: Julie Dawson

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|---------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : FITTING |
| Job Number | : 43657 | | |
| Estimate Number | : 10693 | | |
| P.O. Number | : | Part Number | : D32995 |
| This Issue | : 20/11/2008 S.O. No. : | Drawing Number | : D3299 REV B |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / Type : MACHINED PARTS | Drawing Revision | : B |
| Previous Run | : 40302 | Material | : |
| Written By | : | Due Date | : 21/12/2008 |
| Checked & Approved By | : <u>JUL 08 11 21</u> | Qty: | 16 Um: Each |
| Comment | : Est: A 04.10.04 New issue KJ/JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------------|----------------------|
| 1.0 | M6061T6H1625 | 6061T6 hex bar 1.625 |
|-----|--------------|----------------------|



Comment: Qty.: 0.2013 f(s)/Unit Total: 12077T(s) 5.000ft.

6061T6 hex bar 1.625

#not removed from computer.

Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.625" Hex
 (M6061T6H1.625)

Identify as D3299-5

Batch: M11090809/02/2116 pcs

| | | |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



Comment: HARDINGE CNC LATHE SMALL / HAAS 1

Cut blank: 2.950" long

Turn as per Folio FA465 and Dwg D3299

B.A 09/02/24 / 09/02/2116 pcs

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE B.A 09/02/24 / 09/02/21

16 pcsPTO

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

09/02/24 / 09/02/2116

| | | |
|-----|-----------------|-----------------------|
| 5.0 | OUTSIDE SERV.30 | OUTSIDE SERVICES-MACH |
|-----|-----------------|-----------------------|



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 8317

Anodize as per Dwg D3299

Possible Supplier: TNM Paint

Material release note is required

C 209/03/03163.1 HAAS #1. Machine AS PER FolioB.A 09/02/21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3299-5 PAR #: NA Fault Category: Prod / Eng. Control NCR: Yes ☒ No ☐ DQA: PD Date: 09/03/12
 Resolution: Scrap Process Disposition: Scrap QA: N/C Closed: PD Date: 09/03/12

| NCR: <u>43657</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------|--|-----------------------------|--|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 09/02/21 4 | 2.0 | Hole Ø should be .302 → .307 Actual size is .309-.310 RC → chip build up & programming errors. scrap 3 pcs | <u>BS/ML</u> | use parts for the setup then scrap Qty 3 Replate B ² 110908 (K3) | 09/02/26 | <u>09/02/27</u> | <u>BS/ML</u> | <u>09/02/26</u> |
| | | | <u>BS/ML</u> | review program feeds. | | | <u>BS/ML</u> | <u>09-02-27</u> |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:37:33 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 43657

Part Number: D32995

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage
Ensure Material Release Note is attached

09/03/11 (16)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/03/11 (16)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker,
then Stock
Location: ST86

09/03/11 (X16)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/11

Job Completion



mk
09-03-11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|------------------------------|---------------|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 43657 |
| Description: Fitting | | Part Number: | D3299-5 |
| Inspection Dwg: D3299 | Rev: B | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

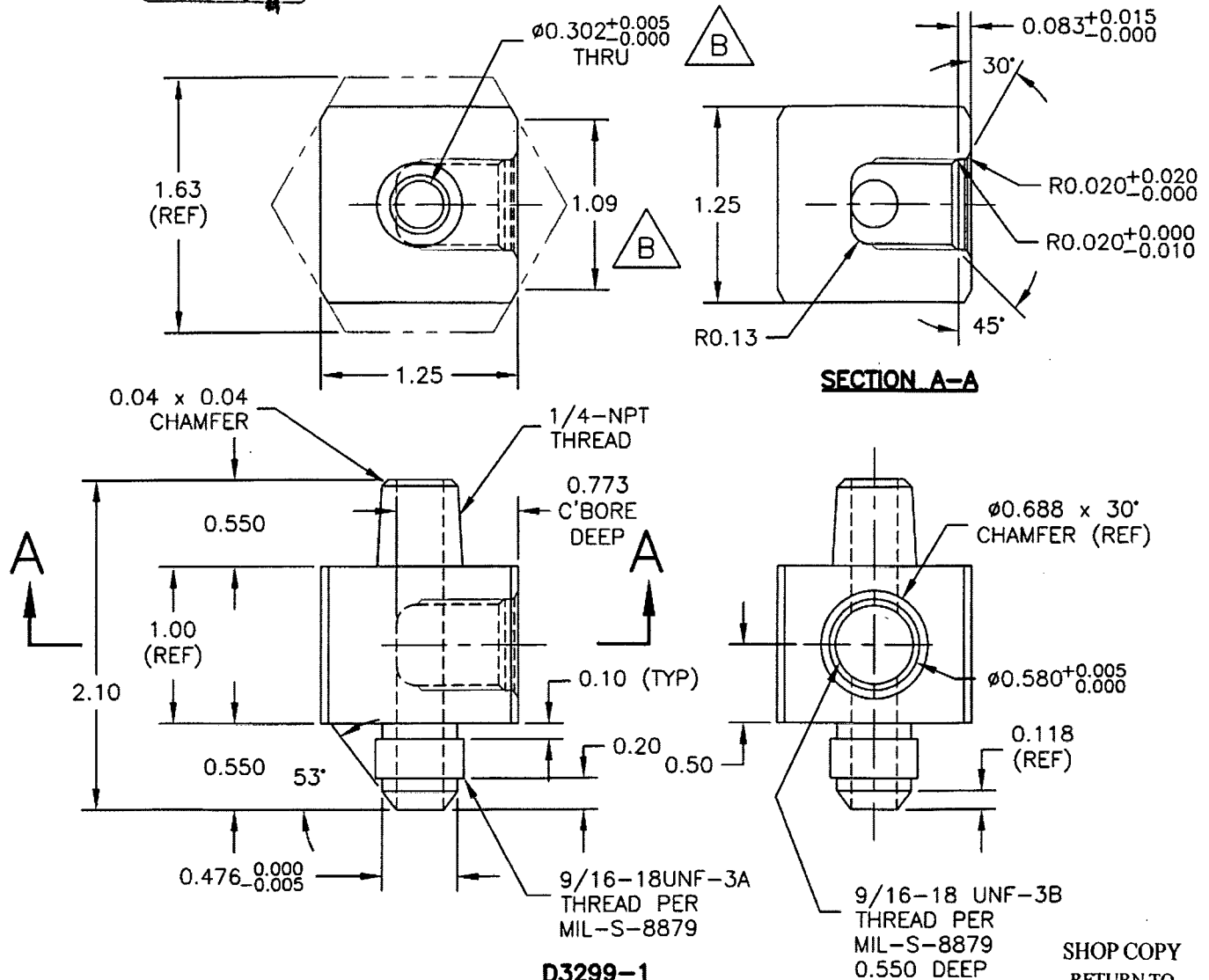
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|------------------------------|------------------|--------|--------|----------------------|----------|
| 1.625 | +/-0.010 | 1.626 | ✓ | | | |
| 1.250 | +/-0.010 | 1.250 | ✓ | | | |
| Ø1.00 | +/-0.030 | 1.002 | ✓ | | | |
| Ø0.560 | +0.005/-0.000 | .561 | ✓ | | | |
| Ø0.302 | +0.005/-0.000 | .3065 | ✓ | | | |
| 0.083 | +0.015/-0.000 | 0.087 | ✓ | | | |
| 30° | +/-0.5° | 30° | ✓ | | | |
| 53° | +/-0.5° | 53° | ✓ | | | |
| 1.00 | +/-0.030 | 1.00 | ✓ | | | |
| 1.700 | +/-0.010 | 1.698 | ✓ | | | |
| R0.06 | +/-0.030 | .06 | ✓ | | | |
| Ø0.476 | +0.000/-0.005 | .476 | ✓ | | | |
| MOW for 9/16"-18 | Min = 0.5742 Max = 0.5708 | .5735 | ✓ | | | |
| 0.20 | +/-0.030 | .185 | ✓ | | | |
| 0.93 | +/-0.030 | .916 | ✓ | | | |
| 0.150 | +/-0.010 | .149 | ✓ | | | |
| Ø0.688 | +/-0.010 | Ø0.690 | ✓ | | | |
| Ø0.580 | +0.005/-0.000 | Ø0.580 | ✓ | | | |
| 0.50 | +/-0.030 | 0.499 | ✓ | | | |
| 2.85 | +/-0.030 | 2.847 | ✓ | | | |

| | | | |
|---------------------------------|--------------------------------|----------------------------|-----|
| Measured by: [Signature] | Audited by: [Signature] | Prototype Approval: | N/A |
| Date: 09/02/24 | Date: 09/02/24 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-------------------|------------|----------|
| A | 04.11.12 | New Issue | KJ/JLM | |
| B | 05.05.25 | Ø0.302 was Ø0.313 | KJ/JLM | |
| C | 08.07.23 | Dwg Rev updated | KJ/DD | |
| D | 08.09.04 | Dimension revised | KJ/DD | |

DART

| | | | |
|------------------|---------------|--|------------------------|
| DESIGN # | DRAWN BY # | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3299 | REV. B SHEET 1 OF 3 |
| DATE 05.04.28 | | TITLE FITTING | SCALE 1:1 |
| A | 04.07.06 | NEW ISSUE | |
| B | 05.04.28 | 1.09 WAS 0.837; $\phi 0.302$ WAS $\phi 0.297$ | |

RELEASED
05.04.28 #**D3299-1 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6M163)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

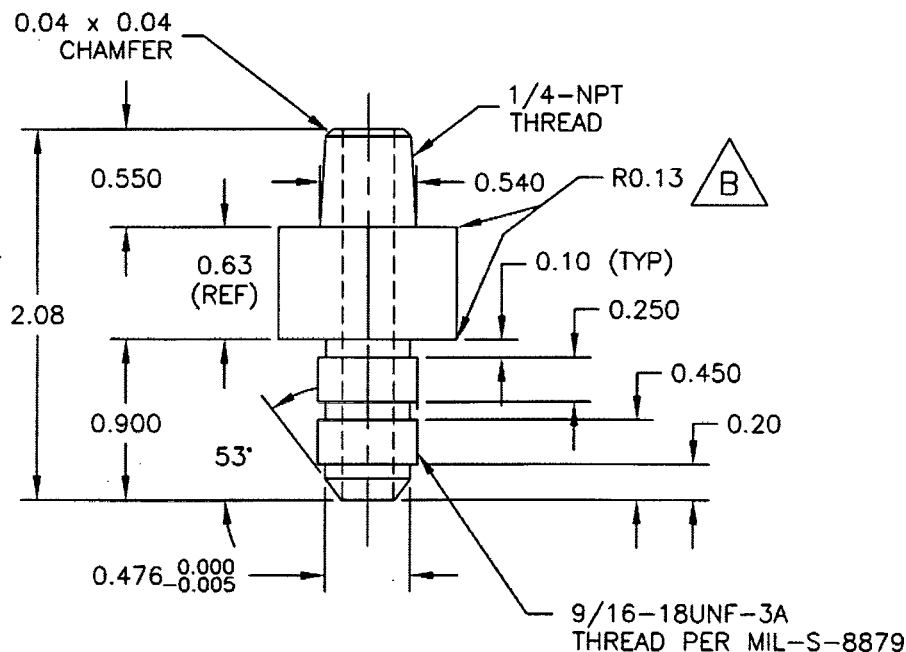
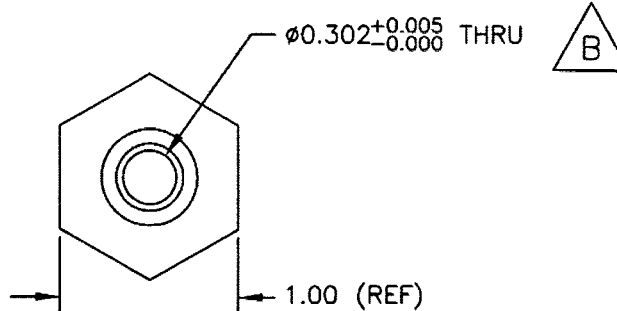
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| | | | |
|------------------|---------------|---|------------------------|
| DESIGN # | DRAWN BY # | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3299 | REV. B SHEET 2 OF 3 |
| DATE 05.04.28 | | TITLE FITTING | SCALE 1:1 |

RELEASED
05.04.28**D3299-3****D3299-3 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1.000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

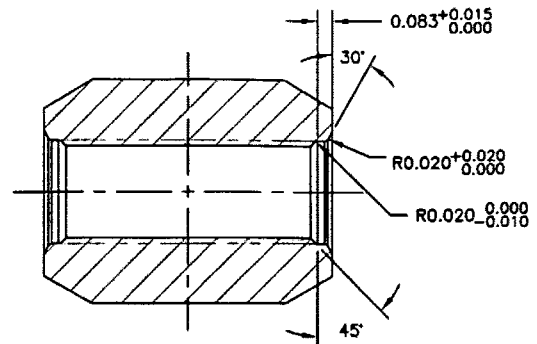
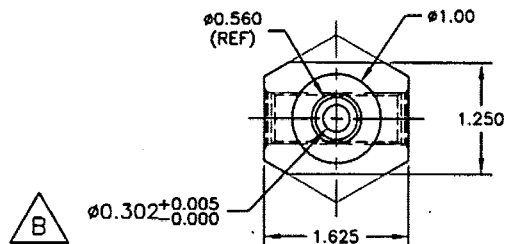
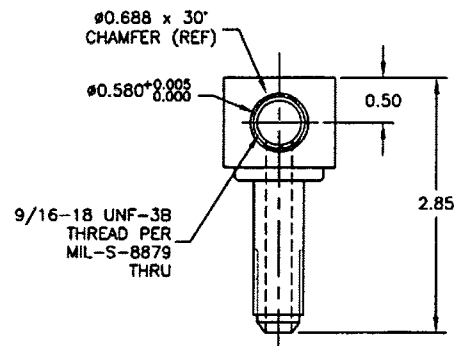
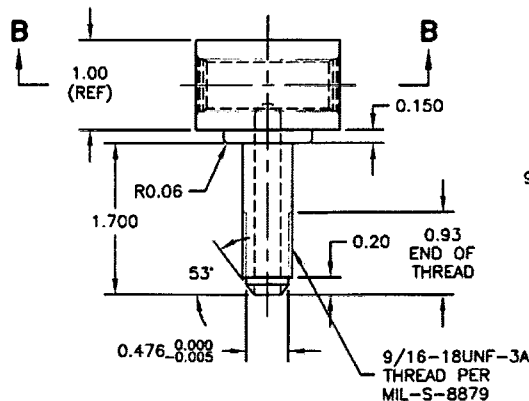
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| | | | |
|------------------|---------------|---|------------------------|
| DESIGN # | DRAWN BY # | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3299 | REV. B SHEET 3 OF 3 |
| DATE 05.04.28 | | TITLE FITTING | SCALE 1:2 |

RELEASED
05.04.28**SECTION B-B**
SCALE 1:1**D3299-5****D3299-5 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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TNM

ANODISATION et PEINTURE TNM INC.**FACTURE
INVOICE**

21 chemin de l'Aviation, Pointe-Claire, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

Certifié NADCAP certified

73145 Rev.00

06-Mar-2009

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**NO. DE COMMANDE:
PURCHASE ORDER/ 8317****CONDITIONS / TERMS:****NET 30 JOURS / NET 30 DAYS**

| ITEM | COMMANDE ORDERED | EXPEDIE SHIPPED | PART NUMBER | DESCRIPTION | PRIX UNITAIRE UNIT PRICE | EXTENSION |
|------|---------------------|--------------------|-------------|--------------------------|-----------------------------|-----------|
| 1 | 16 | 16 | D3299-5 | B43657 | \$0.00 | \$0.00 |
| | | | | MINIMUM CHARGE | | \$125.00 |
| | | | | SUB TOTAL: | | \$125.00 |
| | | | | TPS/GST: | | \$6.25 |
| | | | | TVQ/PST: | | \$0.00 |
| | | | | TOTAL AMOUNT DUE: | | \$131.25 |

No de TPS / GST # : 891559734 RT

No de TVQ / QST # : 1019307154 TQ000

CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE**CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS**

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilit  se limitera   deux fois la valeur du traitement des pieces perdues ou endommag es.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

73145

06-Mar-2009

**CLIENT / CUSTOMER:**

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE**CERTIFICAT DE CONFORMITE**NO. DE COMMANDE: 8317
PURCHASE ORDER

| ITEM | COMMANDE ORDERED | EXPEDIE SHIPPED | PART NUMBER & DESCRIPTION | PART PROCESS & TREATMENT |
|------|---------------------|--------------------|---------------------------|---|
| 1 | 16 | 16 | D3299-5 B43657 | BLUE ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER |

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed: 
☐ Directeur de la Qualité / Q.A. Manager ☐ ☐

DART

Purchase Order

| | |
|-------------------------------------|-----------|
| Date Mar 03, 2009 | Page 1 |
| Purchase Order Number PO00008317 | |

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

REVISED

Vendor Address:

Anodizing & Paint T.N.M. Inc.
21 Aviation Road
Pointe Claire, QC H9R 4Z2
Phone (514) 429-7777
Fax (514) 429-5108

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

| Reference | Contact | Vendor Number | PO Date | Terms | Ship Via | Expected Arrival |
|-----------|---------|---------------|--------------|-------|-----------|------------------|
| | | VC-AND002 | Mar 03, 2009 | N30 | Purolator | Mar 10, 2009 |

| Qty. Ordered | Item Number | Description | Expected Arrival | Drop-Ship | Unit Cost | UOM | Extended Price |
|------------------------------|----------------|---|------------------|--|-----------|---|----------------|
| 16.0000 | D3299-5 B43657 | BLUE ANODIZE Comments: BLUE ANODIZE AS PER MIL-A-8625F TYPE 1 OR 1B / IC II / IIB CLASS 2 B43657 | 10/03/2009 | No | 7.812500 | | 125.00 |
| Comments: <i>REVISED: \$</i> | | Tax Summary: GST 6.25 GSTME 0.00 GSTND 0.00 | | Less: included tax 0.00 Subtotal 125.00 Total tax 6.25 Total purchase order in CAD Dollars 131.25 | | Entered By: <i>CL</i> CLAVOIE Approved By: _____ | |